

Work Order ID 133292

133292

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June-01-15 1:49:02 PM

Item ID: MISC - Testing Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Eng Testing

Start Date: 6/01/15 Start Qty: 1.00 *1* 3
 Required Date: 6/05/15 Req'd Qty: 1.00 *2* 3
 Cust Item ID:
 Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100	0.00					3			DAS 41 9-89
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100

Crosstubes

Crosstubes

Memo

- PICK D6021
- MACHINE TO 2.3" OD
- GRIND SURFACE SMOOTH USING GR80 DRUM BELT AND FINISH WITH A COARSE BLENDEXTM DRUM (WALTER SURFACE TECHNOLOGIES). CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- DEGREASE USING 4105S WASH 'N WIPE. USE CLEAN LINT FREE CLOTH. RINSE ANY RESIDUE THOROUGHLY, WIPE/DRY WITH CLEAN DRY CLOTH TO ENSURE SURFACE CONTAMINANTS REMOVED.
- KEEP ALL SURFACES CLEAN UNTIL PRIMED. USE CLEAN GLOVES TO HANDLE. SURFACES SHALL BE KEPT FREE FROM DIRT, DUST, FINGER MARKS, AND OTHER CONTAMINANTS.

3 J.C.L. 15/06/08

JW 15-06-10

Qty (3)

6" long pieces

15/6/14

15-6-18

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 41 9-89
110						3			
Crosstubes	Memo	0.00							15-6-18
Crosstubes	6. APPLY SHERWIN WILLIAMS DOD-P-15328D PER MANUFACTURER'S INSTRUCTIONS. 132240								
	7. PRIME AND PAINT OUTSIDE OF TUBE PER DART QSI 005 4.2								
	8. CUT INTO (3) 6" LONG SECTIONS								
	Prime 131846								
	Paint 132422								
120		0.00							DAS 12 9-89
120						3			
Eng	Memo	0.00							15/6/19
Engineering	ENGINEERING APPROVAL								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Purchasing	Memo	0.00							
Purchasing	SEND TO EXOVA FOR GRAVEL TESTING PO <u>28902</u>								

140 QC21- Final Inspection - Work Order Release 0.00
 140 0.00
 QC Memo
 Quality Control

PD 15 74801

SA 20150917

*DAS
12
889
15/6/22*

Linda Lacelle

From: Chris Provencal
Sent: June-01-15 1:26 PM
To: Linda Lacelle
Cc: William Monterroza; Nigel Forbes
Subject: Need Gravel Test Samples

Linda,

Can we have 4 w/o's to create the following. This is for gravel testing at Exova:

W/O #1, Existing process (control)

Cut qty(3) 6" long sections from painted 350 tube. This tube is already painted, so it just needs to be picked. We'll pick the fill in the p/n & b/n of the picked tube.

W/O #2, Stainless w/ Metalok

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Apply Axalta 13205S Aluminum Cleaner per manufacturer's instructions
7. Apply Axalta Metalok 230S Adhesion Promoter per manufacturer's instructions
8. Prime and paint outside of tube per Dart QSI 005 4.2
9. Cut into (3) 6" long sections

W/O #3, Stainless w/ Military wash primer

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.

5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Apply Sherwin Williams DOD-P-15328D per manufacturer's instructions.
7. Prime and paint outside of tube per Dart QSI 005 4.2
8. Cut into (3) 6" long sections

W/O #4, Stainless w/ powder coat

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
5. Keep all surfaces clean until primed. Use clean gloves to handle: Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Powder coat white (4.3.5.2) per Dart QSI 005 4.3
7. Cut into (3) 6" long sections

The D6021 material should be able to be cut from the excess mat'l on the ends of the raw extrusion. I believe there's at least 12" extra material on each tube.

Thanks,
Chris

